

Date: Wednesday, 6/27/2007 8:43:07 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : JOGGLE BRACKET
 Job Number : 33145
 Estimate Number : 12912
 P.O. Number : N/A Part Number : D35801
 This Issue : 6/27/2007 S.O. No. : N/A Drawing Number : D3580 PREL A07.06.25
 Prsht Rev. : NC Project Number : N/A
 First Issue : 6/26/2007 Type : SMALL / MED FAB Drawing Revision : UNDER REVIEW
 Previous Run : N/A Material : N/A
 Written By : ER Due Date : 6/29/2007 Qty: 40 Um: Each
 Checked & Approved By :
 Comment : Est Rev : A New Issue 07.06.25 EC

Additional Product

POSITIVE RECALL

EFFECTIVE 07-06-27 AUTH UPOSITIVE
RECALLRELEASED U DATE 07-06-27

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S18GA 304/316 .050 Sheet



Comment: Qty.: 0.0105 sf(s)/Unit Total : 0.4200 sf(s)

304/316 SS sheet 0.050" thick

Batch: M 100997 IB 07-06-27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3580

Dwg Rev: AProg Rev: A2-Deburr if necessary IB 07-06-27

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-06-27

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

En 07-06-28counted
(40)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Bend as per dwg D3580

IB 07-07-106(34)

Date: Monday, 09/07/2007 7:11:30 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JOGGLE BRACKET

Job Number: 33145

Part Number: D35801

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.1

POWDER COATING

POWDER COATING



Comment: POWDER COATING

6.2

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u A.A-12

Date: Wednesday, 6/27/2007 8:43:08 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JOGGLE BRACKET

Job Number: 33145

Part Number: D35801

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

LE 07.04.06

7.0

PACKAGING 1

PACKAGING RESOURCE #1



POSITIVE
RECALL

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

6.1 Powder coat grey sandtex (4.3.5.6) per
Q51 005

6.2

QC3

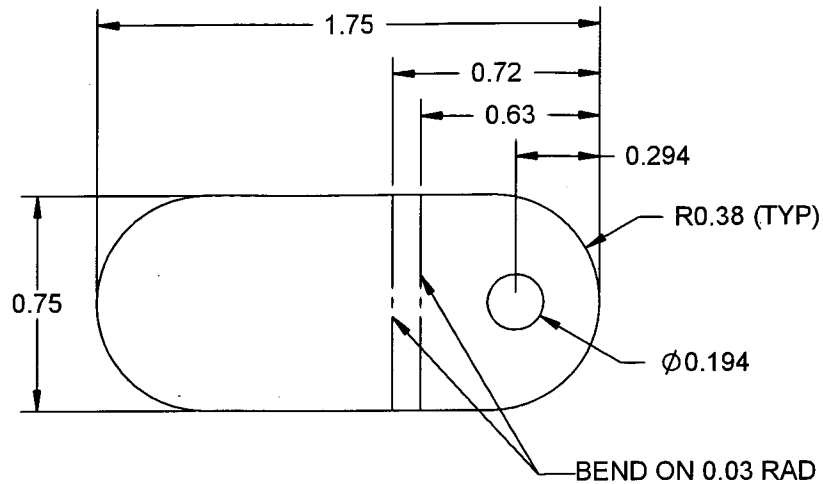
BB

per

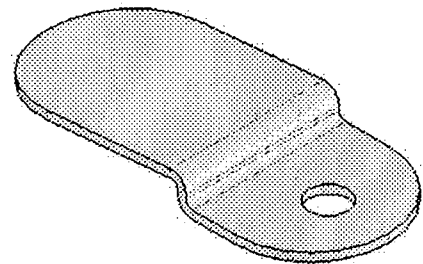
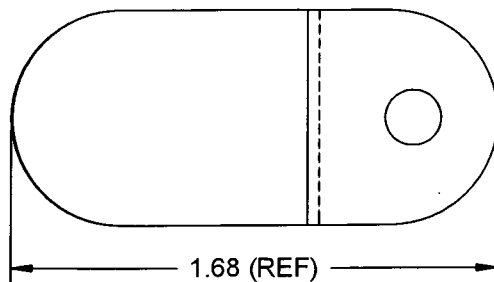
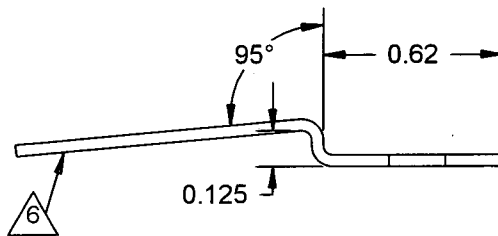
PRELIMINARY ISSUE

LE 07.06.28

DESIGN LE	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED	DRAWING NO. D3580	REV. A SHEET 1 OF 1
DATE 07.05.15		TITLE JOGGLE BRACKET	SCALE 3:2
REV A	DATE 07.05.15	DESCRIPTION NEW ISSUE	



D3580-1F FLAT PATTERN



D3580-1 JOGGLE BRACKET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK)
PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER
ON THE UNDERSIDE OF THE PART AS INDICATED

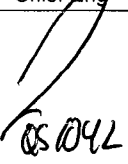


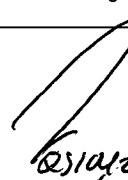
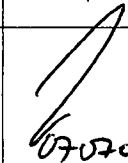
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/06	S	6 piece were scrap out of tolerance	 05/04/06	Scrap - destroy	 07/07/06	 07/07/06	 05/04/06	 07/07/06

NOTE: Date & initial all entries